

# Work Order ID 70462

Thursday, June 09, 2011 7:41:28 AM



Page 1

Item ID: D3535-33

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 6/9/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/13/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

*H*

Date:

*6/1-06-9*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3535	Rev B								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3535 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-  
Deburr if necessary

304: 040

B11-6-10

*(10)*

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-6-10

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

*8 u66113*

*(710)*

# Work Order ID 70462

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Page 2

Item ID: D3535-33

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 6/9/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/13/2011 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130



Brake NC

NC BRAKE

0.00

Memo

0.00

Brake NC

1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326. □2-Identify as D3535-33.

SB 11/6/13

(10)

140



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

S 11/6/14

(40)

150



Powdercoat

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

0.00

Powder Coating

START TIME: \_\_\_\_\_ □OVEN TEMPERATURE: \_\_\_\_\_

□FINISH TIME: \_\_\_\_\_

11:30

12:00

320 OF

M 11/5/128

10x Ø M-L 11/06/14

**Work Order ID 70462**

Thursday, June 09, 2011 7:41:28 AM



Page 3

Item ID: D3535-33

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 6/9/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/13/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10 BR 11-6-14

170

Identify as per dwg & Stock Location: FP-19 0.00

Packaging

Memo

0.00

Packaging

10X ✓ M-11/06/14

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/15

MF 11-06-14

# Picklist Print

Thursday, June 09, 2011 7:41:26 AM

Page 1

Work Order ID: 70462

Parent Item: D3535-33

Parent Item Name: Wearshoe





Start Date: 6/9/2011

Required Date: 6/13/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-02-15 JLM  
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 		Purchased	No			100	sf	249.9814	0.6445	4.070526			
													

304/316 .040 Sheet

6.5

PB11-6-10

Location

Loc Qty

Loc Code

MAT020

249.9814

116623

0.2

117550

10.1814

117933

239.6

17933

10

DART AEROSPACE LTD		Work Order: 70462
Description: Wearshoe		Part Number: D3535-33
Inspection Dwg: D3535	Rev: B	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.188	+0.005/-0.001	.192	2		V HB02	
0.300	+/-0.010	.304	U		V	
0.300	+/-0.010	.307	X		V	
1.885	+/-0.010	1.889	X		V	
2.000	+/-0.010	2.002	Y		V	
6.000	+/-0.010	6.000	L		T B01	
9.500	+/-0.010	9.500	-		T	
15.250	+/-0.010	15.250	U		T	
21.000	+/-0.010	21.000	6		T	
24.500	+/-0.010	24.500	8		T	
6.00	+/-0.030	6.00	L		T	
6.75	+/-0.030	6.75	7		T	
13.50	+/-0.030	13.50	6		T	
0.040	+/-0.010	.037	X		V	

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 11-6-10	Date: 11/6/13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.10.16	New Issue	KJ	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

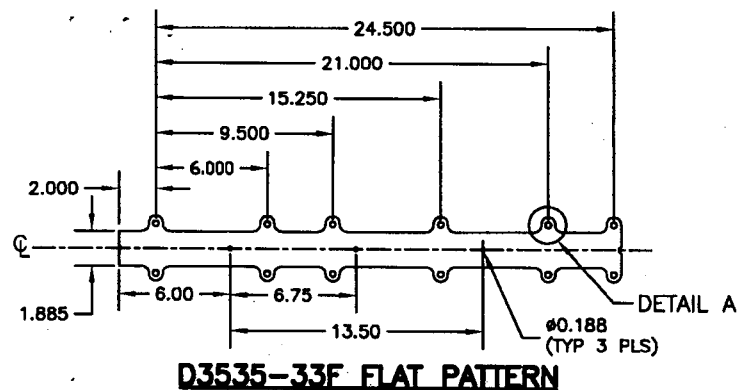
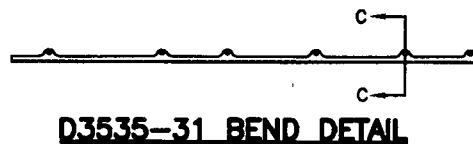
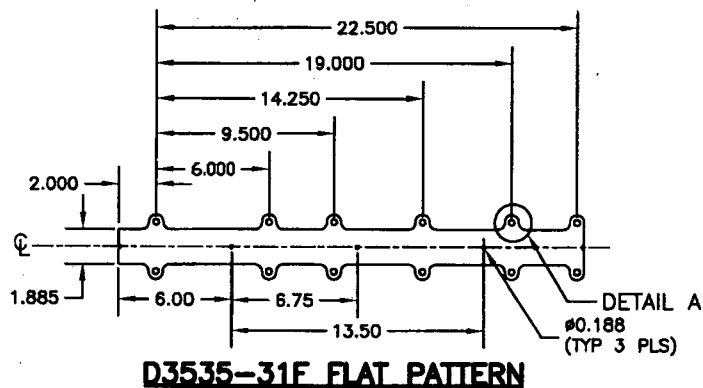
DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CB	PH	PORT HADLOCK, VA	
CHECKED	APPROVED	DRAWING NO.	REV. B
<i>[Signature]</i>	<i>[Signature]</i>	D3535	SHEET 4 OF 7
DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	

RELEASED

07.04.24

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 70462

*pl 11-06-9*



**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDETEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT  $\bar{C}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

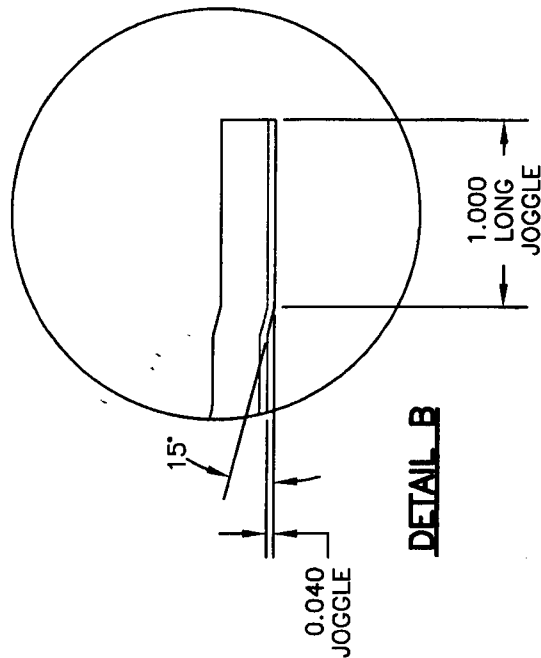
NOTE: Date & initial all entries



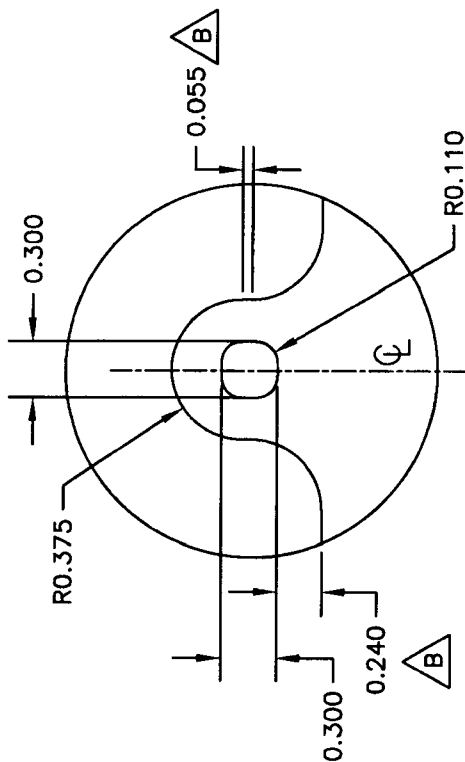


DESIGN <b>CB</b>	DRAWN BY <b>PH</b>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3535</b>	REV. B SHEET 7 OF 7
DATE <b>07.04.17</b>		TITLE <b>WEARSHOE</b>	SCALE 1:1

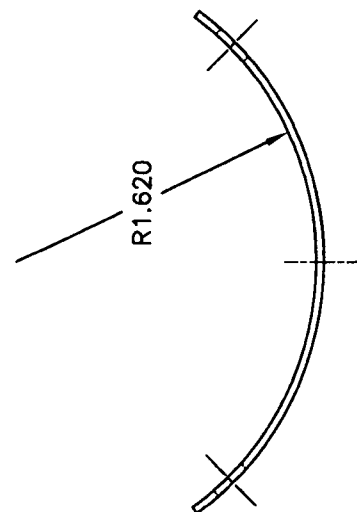
RELEASED  
07.04.24 *[Signature]*



**DETAIL B**



**DETAIL A**



**SECTION C-C**

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries